

Work Order ID 106529

Friday, September 06, 2013 11:20:15 AM

106529

UPDATE FROM OFFSHORE

Page 1

Item ID: D350-636-215 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible
 Start Date: 9/5/2013 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/13/2013 Req'd Qty: 1.00 *1* Customer:
 Reference: ECN 13-535

Approvals: Process Plan: WUF Date: 9-9-6 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-636	J								

190

0.00

190

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D350-636-215 X 1 B85190

106529

REMOVE OLD PAPERWORK AND REPLACE WITH NEW

ADD 1 X D3456-1 TO KIT AND UPDATE TO CHANGE 005

ID AND STOCK UNDER NEW BATCH NUMBER

9/17/13

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

Work Order ID 106529

106529

UPDATE
FROM
OFFSHORE

Friday, September 06, 2013 11:20:15 AM

Page 1

Item ID: D350-636-215 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible
 Start Date: 9/5/2013 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/13/2013 Req'd Qty: 1.00 *1* Customer:
 Reference: ECN 13-535

Approvals: Process Plan: WUF Date: 13-9-6 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-636	J								

190 0.00

190

Packaging Memo 0.00
 Packaging PULL FROM STOCK D350-636-215 X 1 B85190

REMOVE OLD PAPERWORK AND REPLACE WITH NEW
 ADD 1 X D3456-1 TO KIT AND UPDATE TO CHANGE 005
 ID AND STOCK UNDER NEW BATCH NUMBER

200 QC5- Inspect part completeness to step on W/O 0.00

200

QC Memo 0.00
 Quality Control

Work Order ID 106529***106529***

Page 2

Friday, September 06, 2013 10:32:17 AM

Item ID: D350-636-215 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible
Start Date: 9/5/2013 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/13/2013 Req'd Qty: 1.00 ***1*** Customer:
Reference: ECN 13-535

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

mf mcs 13-09-18
13-9-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

Friday, September 06, 2013 10:32:17 AM

Page 1

Work Order ID: 106529

Parent Item: D350-636-215

Start Date: 9/5/2013

Required Date: 9/13/2013

Parent Item Name: Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.10.04 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553
DD verf:EC IPP Rev:C 112.04.16 AS PER ECN 12-542 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3456-1 Washer		Manufactured	No				Each	131.0000		1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		7							
				25701		7							
				ST047		124							
				103539		50							
				103787		25							
				80252		1							
				85223		1							
				89237		6							
				96570		21							
				99338		20							
D350-636-215 Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible		Manufactured	No				Each	0.0000		1			

mf 13-9-16

1205790
mf
13-9-6

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

REVISION RECORD

Revision	Issue Date	Description
A	98.04.16	New Issue
B	98.09.02	Change blade bolt to AN8-16A
C	98.11.19	Add -013/-014 skid tubes for Aircruiser compatibility
D	06.01.03	Add compatibility with Apical Tri-bag Floats and Apical Cylindrical Floats
E	07.05.15	Change wearplates to stainless steel; Re-organize installation procedure.....pg. 4-7; Add Dart D350-748 crosstube compatibility.....pg. 3; Incorporate DSI 9343.....pg. 6,13; Replace D350-636-041 kit with -043 kit.....pg. 12,13; Item 17 now D3631-1 Washer.....pg. 12; Item 18 now ALS4-1032-225.....pg. 12; Removed * from items 9-12.....pg. 12; Add rubber gaskets, item 23B, 24B, 25B.....pg. 13; Remove NAS1515H3L washers from the wearshoes.....pg. 13
F	08.08.14	Add note to use Antiseize compound.....pg. 5, 8; Add reference to DSI 9413;.....pg. 6-7; Add D350-636-011/-012/-013/-014 at CHG 004 drawing.....pg. 10; Add Parts List for D350-636-011/-012/-013/-014 at CHG 004....pg. 17
G	10.07.12	Incorporated DSI 9456, DSI 9457, DSI 9490 Fixed typo on pg. 3, 355A41-2002-03 changed to 355A41-2001-03
H	10.07.28	Add D350-636-015/-016/-017/-018/-047 kits.....pg. 13; Add Parts List for D350-636-015/-016/-017/-018/-047.....pg. 29; Add D350-636-215/-216/-217/-218 Kits.....pg. 13; Add Parts List for D350-636-215/-216/-217/-218.....pg. 31
I	10.10.25	D4170-3 Spacer was D4170-1pg. 10,30; Drill size for D4170-3 Spacer is Ø0.453" (was Ø0.313 for -1)....pg. 10
J	13.03.01	Incorporate DSI 9570.....pg. 3; Ø0.633" was Ø0.625" section 3.10.1.....pg.10; Revised section R-Rpg. 17; Update Weight and Balance for D350-636-047.....pg. 22; Add 1X D3456-1 to D350-636-109.....pg. 28

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR
COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: J

Date: 13.03.01

List Lots

September-05-13 11:19:21 AM

Page 1 of 1

Criteria : Item ID: 'D350-636-215', 'D350-636-216', 'D350-636-217', 'D350-636-218'

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	All Locations	All Warehouses	All Quantity	Type Code	Comments
D350-636-215 Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible										
	Main Warehouse FG	91248 #106529	6/05/13	1.0000		QC21		CHG004		Angle of 1.44*
	Main Warehouse FG072	97328 #106525	5/10/13	1.0000		QC21		CHG004		Angle of 2.73* . Ship Local
	OFFSHORE FG	85190 #106529	5/22/13	1.0000		QC21		CHG004		
	OFFSHORE FG	91245 ±106530	5/10/13	1.0000		QC21		CHG004		
	OFFSHORE FG	91246 #106531	6/05/13	1.0000		QC21		CHG004		
Total:				5.0000						
D350-636-216 Deluxe Skidtube RH Aerazur / Apical Cylindrical Float Compatible										
	Main Warehouse FG073	91252 #106532	5/10/13	1.0000		QC21		CHG004		Angle of 2.56* . Ship local
	OFFSHORE FG	85193 #106533	5/22/13	1.0000		QC21		CHG004		
	OFFSHORE FG	91249 ±106531	5/10/13	1.0000		QC21		CHG004		
	OFFSHORE FG	91250 ±106535	6/05/13	1.0000		QC21		CHG004		
Total:				4.0000						
D350-636-218 Deluxe Skidtube RH Air Cruiser / Apical Tri-Bag Float Compatible										
	Main Warehouse FG073	91253 ±106536	5/10/13	1.0000		QC21		CHG004		Angle of 1.98*
Total:				1.0000						

101114
106536